Work Orde Triday, June 21,			<u> </u>	<u>*109</u>	366*		v . — . =.=					Page 1	·. ==
tem ID: Revision ID: tem Name:	D3914-1 Rib 6/21/2013	Start Qty: 6.00	*@*	Accept	*N900		100)* :	Setup	Start Stop	*NS		. <u>-</u> -
Required Date: Reference:		Req'd Qty: 6.00	*6*	•	Customer:								
Approvals:	Process Pla	n:	Date: /3-//	Tooling: SPC (Y/N):		ate:	·— ——	J	Run	Start Stop	*NF		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revi	ision Nbr				· — —							
D3914													
100	· · · · · · · · · · · · · · · · · · ·			0.00		- 		×8		12	-08-	29	11/1
100 Large Fab		Memo		0.00				<u>~O</u>			00 0	<u>~ 1</u>	<i>(*</i> 17 ,
Large Fab		I - Cut tube	as per dwg D3914 d remove identificatio	n markings									
110		QC6- Inspect dimension	s to drawing	0.00									
110								8x_		M	13.08	329	1
QC Quality Control		Memo		0.00									
120		Identify as per dwg & St	ock Location:	0.00				0		иl	.		
120 Packaging		Memo		0.00				8.4-			B:08	329	

Packaging

											DQA:	Date:	• .			
NCR: Ye	es /	No				WORK ORDER NON-	CON	IFORN	MANCE / UPC	DATE	QA Closed:	Date:				
Work Orde	:					DISPOSITION	_			PROCESS						
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root Cause	D	ate	Step	Qty		iption of work order update or Non-conformance	L	nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector			
oc/Data quip/Tooling Operator Material etup Other rocess upplier iraining												·				
						F	AUL	T CATE	GORY			·	<u></u>			
Landin	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/L nance iled	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing //rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
Ī	Wa	ve/Tw	ist in Tub	oe .		Folio		Outside Dimensions								

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Work Ordo			*103366*									Page 2			
Item ID: Revision ID: Item Name:	D3914-1			Accept	*N900	<u>0</u> 40	100)*	Setup	Start Stop	*N:	S1* S2*			
Start Date: Required Date: Reference:	6/21/2013 7/19/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						,			
Approvals:	Process Pla	n:	Date:	Tooling:	Date:				Run	Start	*N	R1*			
	QC:		Date:	SPC (Y/N):	Da	ate:	— — —			Stop	*N!	R2*			
Sequence ID/ Work Center II)	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp			
130 QC Quality Control	Memo			0.00					Q12	/ 5-08-	<u>(1/2</u> 36	(

											DQA:	Date:	•	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UF	PDATE		**·		
											QA Closed:	Date:		
Work Orde			•			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
WORK Ordi	er					Rework	1	Skid-tube Crosstube			1	Water Jet	Engineering	
Part !	VIO.				:	Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
l dit:	10.					Use-as-is	1		noforming	Finishing	-	re/Packaging	Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	1	
	-						_			· L			·	
Root					Descri	ption of work order update		Initial	A _f	ction	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector	
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Equip/Taoling	\square							i						
Operator	Ш]											
Material	Щ						1							
Setup	Ш						1							
Other	Щ													
Process	Ш						1							
Supplier	Ш		1						{					
Training	Ш								ĺ					
Unapproved		_		<u> </u>	<u> </u>		1_						<u> </u>	
							AUI	LT CATE	JURY					
Landi		1			[General Bend		Grain			Ovalized		Pressure/Forced	
	\vdash	Bending	at Canas		~/s	BOM/Route	\vdash	Hardwa	uro.	<u> </u>	Over/Under	tolerance	Temperature/Cure	
	Centre Not Concentric to O/S Cracks					Broken/Damaged	\vdash	4	ine ion Incomplete	<u> </u>	Part Incorre		Weid	
⊢					⊢	Burrs	\vdash	- '	ion incomplete	/Linclear	Part Lost/Mi		Wrong Stock Pulled	
	Crushed/Crimped					Contamination	-	Mainte		, official	Part Moved		7 - 1 - 21 - 21 - 21 - 21 - 21 - 21 - 21	
ŀ	Cuffs					Countersink	\vdash	Mislabe		<u> </u>	Positioned V	Vrong		
	Heat Treat Inspection Strip in Tube					Cut Too Short	\vdash	Misread		<u> </u>	Power Loss/	Other		

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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Picklist Print

Friday, June 21, 2013 4:00:04 PM

Work Order ID: 103366

103366

Parent Item:

D3914-1

D3914-1

Parent Item Name: Rib

Start Date: 6/21/2013

Required Date: 7/19/2013

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B

as per dwg revB DD 10.08.18 verified by:EC

IPP Rev;C 11.01.18 chg

qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304TS0.750W.049	- 1	Purchased	No		<u> </u>	100	l —	1,266.072	8	50.52632				
M304TS0		049							**					

304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code	
MAT017	41.4652084		
124492	41.4652084		
WA006	1224.607382		
123484	28.9999555		
125124	369.7539		
125575	225.853527		
M126039 64	600		-641

13-08-29 MAL

NCR: Y	es / No				WORK ORDER NON-C	10:	VFORI	MANCE / UPI	DATE	QA Closed	: Date	e:			
Work Orde	r:				DISPOSITION	1	AGAINST DEPARTMENT/PROCESS Skid-tube Crosstube Water Jet Engineering								
Part N	_				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Pro Rec/Sto	Quality Other				
Root	Date	Ston	Qty		ption of work order update or Non-conformance		nitial ief Eng	Act	ion iption	Sign & Date	Verification	QC Inspector			
Cause	Date	Step	Qty		or Non-comornance	-	ilei Liig		iption	- Date	Vermedien	- Go moposto:			
Doc/Data Equip/Tooling	-	1]	•		ì									
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Material															
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Other	_				•							i k			
Process						1						•			
Supplier											1				
Training															
Unapproved						<u> </u>									
					F	AUL	T CATE	GORY							
Landir	ng Gear				General				_	_	F	_			
	Bending			L	Bend	<u></u>	Grain			Ovalized		Pressure/Forced			
	Centre N	lot Conce	ntric to (D/S	BOM/Route	<u>_</u>	Hardwa		<u> </u>	Over/Unde	<u> -</u>	Temperature/Cure			
	Cracks			<u> </u>	Broken/Damaged		4	ion Incomplete	<u> </u>	Part Incorre	-	Weld			
		/Crimped		ļ	Burrs	\vdash	4	tions Incomplete/U	Jnclear	Part Lost/N	_	Wrong Stock Pulled			
	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		<u> </u>	Part Moved					
	Heat Tre			<u> </u>	Countersink	-	Mislabe		<u> </u>	Positioned '					
	—	on Strip ir	Tube		Cut Too Short	<u> </u>	Misread	đ	L	Power Loss	/surge [Other			
	Ripples			<u> </u>	Drill Holes	-	Offset	o-likai							
	——————————————————————————————————————	Waves in		` _	Drawing	Ŀ	-{	Calibration							
	Turning	Sequence	?		Finish		TOut of :	Sequence							

Outside Dimensions

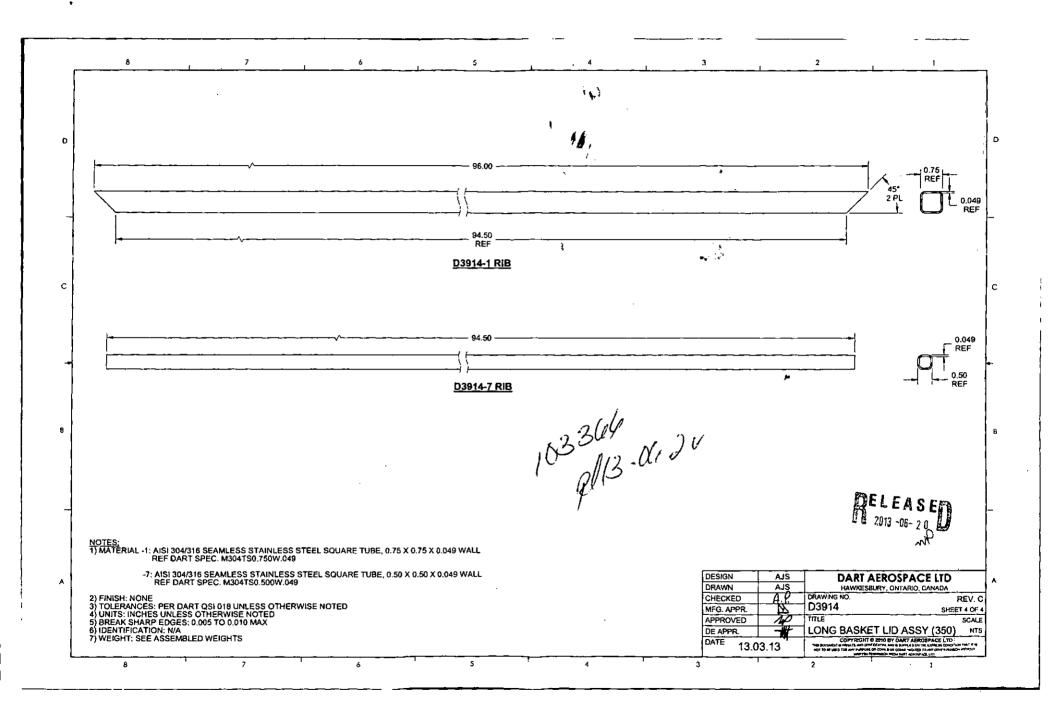
DQA:

Date:

Wave/Twist in Tube

Folio

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											DQA	.:Da	te:	<u> </u>
NCR:	Yes	/ No				WORK ORDER NON-O	:01	NFOR	MANCE / UP	DATE	QA Closed	l: Da	ite:	
Work Orde	or.		-			DISPOSITION AGAINST DI					EPARTMEN	T/PROCESS		
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	Machining Small Fab is Thermoforming Finishing			Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Quality Other
Root					Descri	ption of work order update	П	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	CH	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
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Unapproved			<u>1 : </u>	<u> </u>	<u>L</u>		<u>i</u>		<u> </u>		1		1	
							AUI	LT CATE	GORY		· ·			·'.
Landi		l			,	General		.		_	- 1			*
		Bending			<u> </u>	Bend	<u></u>	Grain			Ovalized		Щ	Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	<u></u>	Hardwa		<u> </u>		er tolerance	Щ	Temperature/Cure
1	Cracks					Broken/Damaged Inspection Incomplete					Part Incorr	ect		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing Finish

Folio

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